

# Work Order ID 165877

Friday, September 01, 2017 9:21:56 AM

**\*165877\***

Page 1

Item ID: D2855 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cap  
 Start Date: 9/1/2017 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 9/1/2017 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference: BLACK SANDTEX

Approvals: Process Plan: [Signature] Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2855    | C            |

150 White Gloss (Ref 4.2.5-1) per QSI005 4.3-Alum 0.00

**\*150\*** 2 φ 17-09-8 15 94 9-89

Powdercoat Memo 0.03

Powder Coating PULL FROM STOCK 2 X D2855 B 177805

REMOVE INSERTS  
SCUFF LIGHTLY

REPOWDERCOAT BLACK SANDTEX

M136890

START TIME: 10:15 OVEN TEMPERATURE:

300 FINISH TIME: 10:45

160 QC3- Inspect Part Finish 0.00

**\*160\*** 2 φ 12/09/15 15 99

QC Memo 0.02

Quality Control

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description                                                        | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------------------|---------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170<br><b>*170*</b><br>Small Fab<br>Small Fab | Small Fab<br>Memo<br>Install Inserts as per Dwg D2855                           | 0.00<br>0.06         |         |        |              |               |               |                  |                |
| 180<br><b>*180*</b><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br>Memo                           | 0.00<br>0.04         |         |        |              |               |               |                  |                |
| 190<br><b>*190*</b><br>Packaging<br>Packaging | Identify as per dwg & Stock Location: <u>FP-001</u><br>Memo<br>LOCATION : FP001 | 0.00<br>0.02         |         |        |              |               |               |                  |                |

x2 of 2008/3

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Reference: BLACK SANDTEX

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 200                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| <b>*200*</b>                   |                                             |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                        | 0.20                 |         |        |              |               |               |                  |                |
| Quality Control                |                                             |                      |         |        |              |               |               |                  |                |

17/9/19



SEP 13 2017

# Picklist Print

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Work Order ID: 165877

**\*165877\***

Parent Item: D2855

**\*D2855\***

Parent Item Name: Cap

Start Date: 9/1/2017

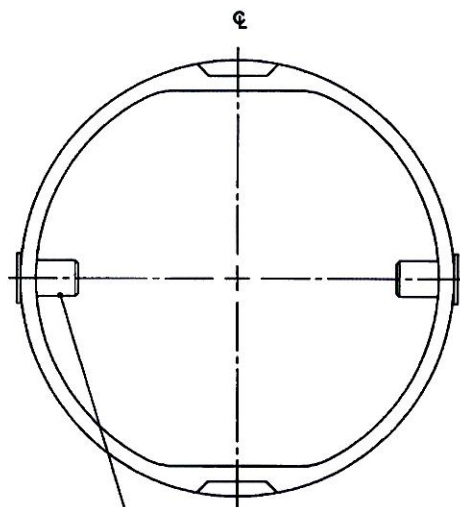
Required Date: 9/1/2017

Start Qty: 2.00

Required Qty: 2.00

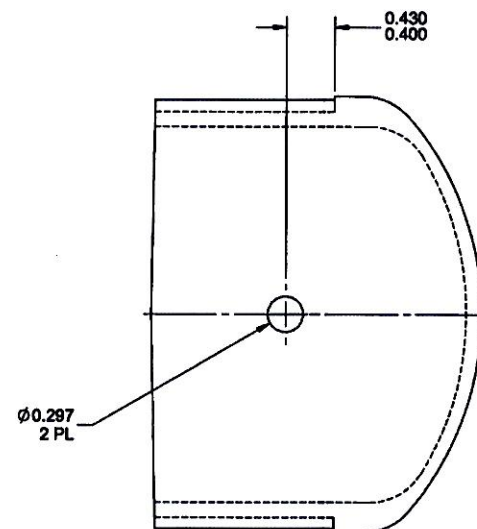
Comments: IPP: B00.06.22Added receiving step & removed P/O for powder coat  
EC

| Component Item ID/<br>Item Name                    | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit     | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|----------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| ALS7-1032-225<br><b>*AI S7-1032-225*</b><br>Insert | AELS8-1032-225         | Purchased     | No          |                     |                  |                 | Each               | 120.0000       | **              | 4            |               | SEP 13 2017    |        |
| M1362GS                                            |                        |               |             |                     |                  |                 |                    |                |                 |              |               |                |        |
|                                                    |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|                                                    |                        |               |             | FG                  |                  |                 | 120                |                |                 |              |               |                |        |
|                                                    |                        |               |             |                     | 118520           |                 | 120                |                |                 |              |               |                |        |
| D2855<br><b>*D2855*</b><br>Cap                     |                        | Manufactured  | No          |                     |                  |                 | Each               | 99.0000        | **              | 2            |               | SEP 13 2017    |        |
|                                                    |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|                                                    |                        |               |             | FP001               |                  |                 | 99                 |                |                 |              |               |                |        |
|                                                    |                        |               |             | 147805              |                  |                 | 34                 |                |                 |              |               |                |        |
|                                                    |                        |               |             | 151613              |                  |                 | 65                 |                |                 |              |               |                |        |



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
2 PL

**D2855 CAP**  
(MAKE FROM D2855C CASTING)



*W/015877*

- NOTES:
- 1) MATERIAL: MAKE FROM D2855C
  - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.63 lbs

RELEASED  
2017-05-08

APPROVED

|            |          |                                                                                                                                                                                                                                                                                       |              |
|------------|----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DS       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                              |              |
| DRAWN      | WK       |                                                                                                                                                                                                                                                                                       |              |
| CHECKED    | RF       | DRAWING NO.                                                                                                                                                                                                                                                                           | REV. C       |
| MFG. APPR. | JFS      | <b>D2855</b>                                                                                                                                                                                                                                                                          | SHEET 2 OF 4 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                 | SCALE        |
| DE APPR.   | DS       | <b>CAP</b>                                                                                                                                                                                                                                                                            | NTS          |
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